

*ASAP*

Date: Thursday, 8/23/2007 11:53:26 AM  
 User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 34243	
Estimate Number : 11162	
P.O. Number : <i>N/A</i>	Part Number : D32641
This Issue : 8/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3264 REV A
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 33066	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/3/2007 Qty: <i>8</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est A 04.09.02 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"
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Comment: Qty.: 0.5097 f(s)/Unit Total : 3.0580 f(s)  
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick  
 (M6061T6B1.250x04.500)  
 Identify for D3264-1  
 Batch: *M105531 DTP 07/12/18*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks: 4.500" x 1.250" x 5.700" long Bar *DTP 07/12/18*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA447 and Dwg D3264  
 Identify as D3264-1  
 Deburr *DTP 07/12/18 J.L*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE *J.L 08/12/20*


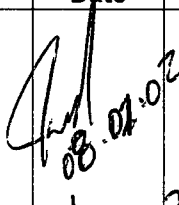
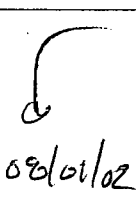
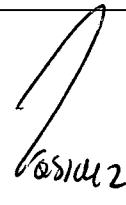
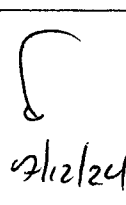

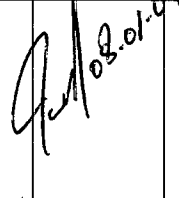
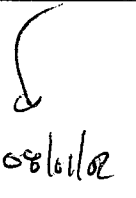
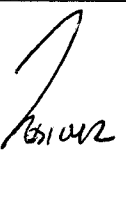
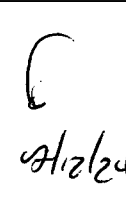


5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK *J.L 08/01/02 (x8)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: AD Date: 08/01/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/20	3	1 part is crooked, crushed by vise R.C. Hammerman error		scrap + replace Qty 7 <u>BM105531</u>	 08.01.02	 08/01/02		 07/12/24
"	3	1 part is too thin and holes are off by .020 R.C. Part was not flat on vise operation error		scrap + replace Qty 1 <u>BM105531</u>	 08.01.02	 08/01/02		 07/12/24
"	3	2 parts holes are off by .020 R.C. origin was off operator error	LE 08.01.02	Acceptable	LE 08.01.02	 08/01/02	LE 08.01.02	 07/12/24

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:26 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 34243

Part Number: D32641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*JD*

*08-01-10*

*(X)*

7.0

POWDER COATING

POWDER COATING



*M106379*



*(8X)*

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

*M-H*

*08/01/10*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-04-10*

*(X)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *57164*

*Re 8/1/10*

*(8)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/01/10*

Job Completion



*2008/1/11*

*W*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34243
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.6875	✓			
0.063	+/-0.010	0.062	✓			
0.125	+/-0.010	0.1235	✓			
0.875	+/-0.010	0.875	✓			
0.062	+/-0.010	0.064	✓			
R0.03	+/-0.030	0.03	✓			
R0.13	+/-0.030	0.125	✓			
1.00	+/-0.030	1.006	✓			
0.125	+/-0.010	0.1265	✓			
0.600	+/-0.010	0.591	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	0.753	✓			
Ø0.194	+0.005/-0.000	0.196	✓			
5.50	+/-0.030	5.501	✓			
0.125	+/-0.010	0.126	✓			
0.063	+/-0.010	0.066	✓			
R0.25	+/-0.030	0.250	✓			
4.27	+/-0.030	4.270	✓			
R0.30	+/-0.030	R0.300	✓			

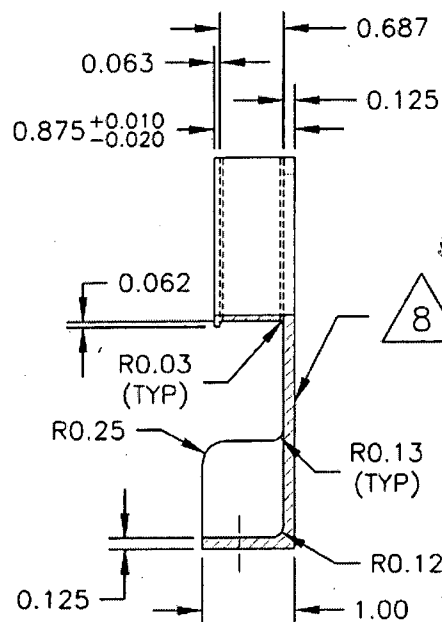
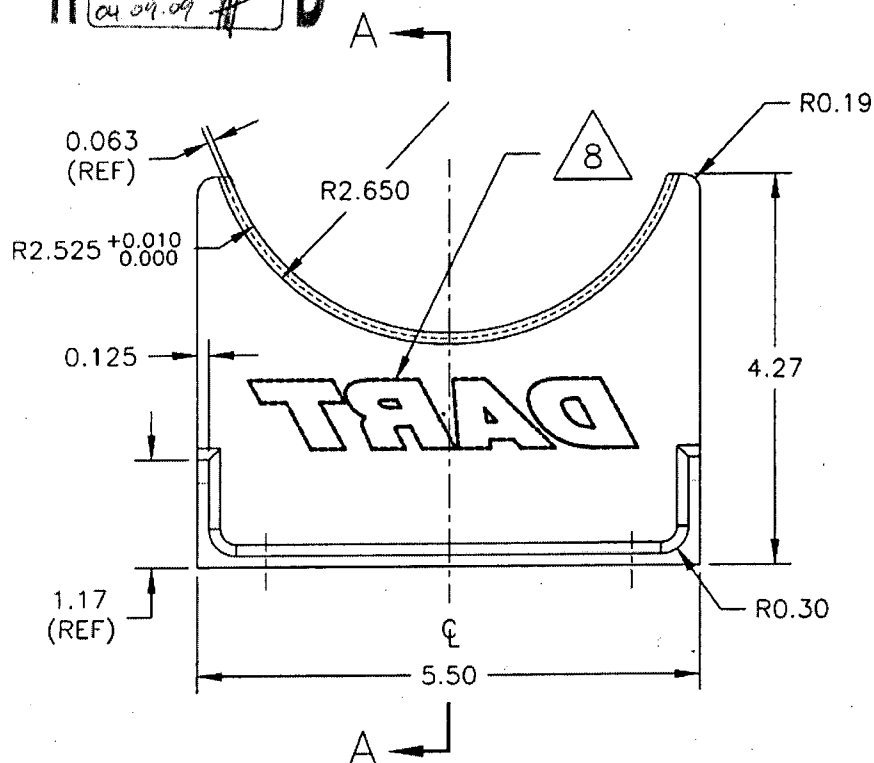
Measured by: DJP	Audited by: SA	Prototype Approval:	N/A
Date: 07/12/19	Date: 07.12.20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	

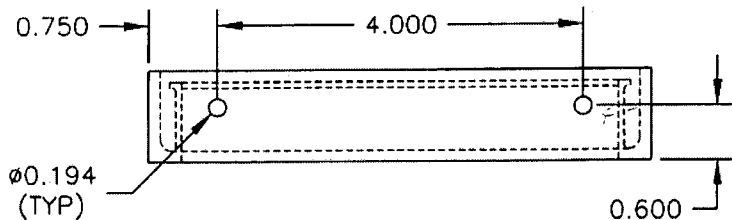


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED  
04.04.09 JH



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. 160001768)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 34243

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